



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBD29932
Job Sheet 193874



Part No: RBD29932

Job Qty: 1 pcs

Part Name: Main Rotor Puller "D" Model (3 Jaw) AI



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *orden 14925*

Note: DWG RBD29932 REV A IPP Rev. A 19.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S203232



Part: RBD29932

Job No: 193874

Serial No/Batch: S203232

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 08/07/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	6/28/19		0.00	0.50	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	6/28/19		0.00	0.00	QC 5 - 10		AUG 1 2 2019 DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	6/28/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	6/28/19		0.00	0.00	QC 21 - FG - 21		DAS 21 9-89 AUG 1 3 2019 GA166F
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG. See note 8,9,10 and 11.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

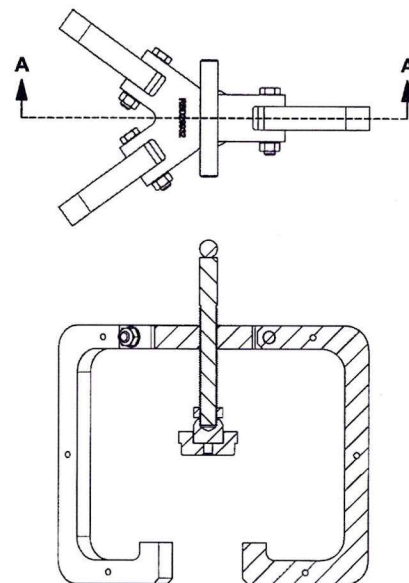
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
51331 AN315-8R	Hex Nut	3 Ea (3 ea)	100-Small Fab - 1	5143734
199 AN8-24A	BOLT	3 Ea (3 ea)	100-Small Fab - 1	5124555
200 NAS1149F0832P	Washer AN960-816L	6 Ea (6 ea)	100-Small Fab - 1	5076018
1414 RBD29932-1	Puller Nut	1 pcs (1 ea)	100-Small Fab - 1	5188064
143F RBD29932-2	Puller	3 pcs (3 ea)	100-Small Fab - 1	5196513
141C RBD29932-3	Thrust Pad	1 pcs (1 ea)	100-Small Fab - 1	5186317
141 RBD29932-4	Puller Screw	1 pcs (1 ea)	100-Small Fab - 1	5177064
202 TP-750	Black Oxide Steel Toggle Pad, Type TP, 3/4"-10 X 1-1/4" OD.	1 Ea (1 ea)	100-Small Fab - 1	5192278

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN315-8R	3	75	0
	AN8-24A	3	10	0
	NAS1149F0832P	6	255	0
	RBD29932-1	1	0	0
	RBD29932-2	3	0	0
	RBD29932-3	1	0	0
	RBD29932-4	1	0	0
	TP-750	1	0	0
Part Specifications				
Specifications could not be found.				

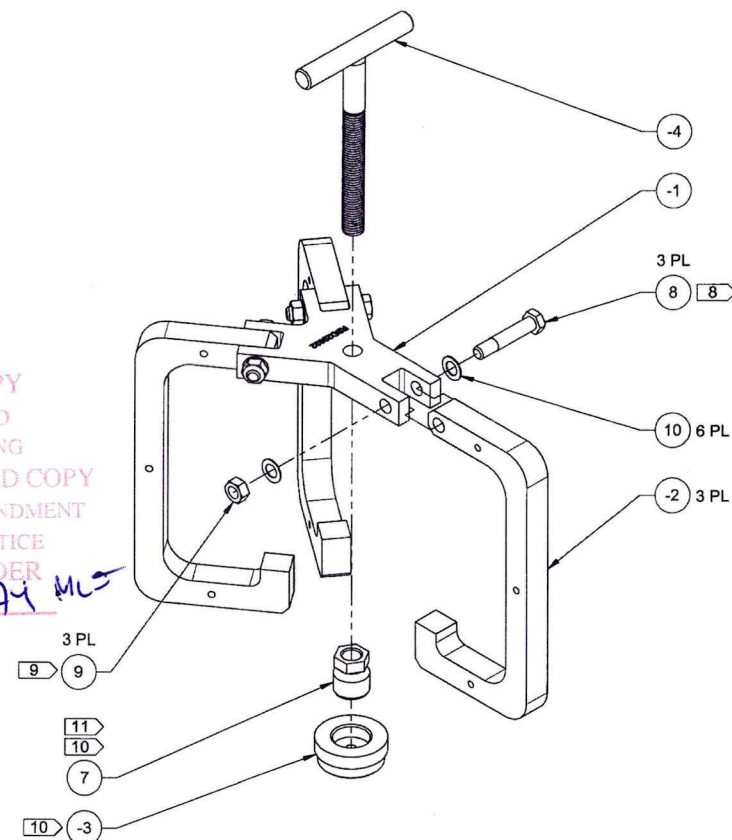
Plex 4/24/19 8:00 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RBD29932-1	PULLER NUT
-2	3	RBD23392-2	PULLER
-3	1	RBD29932-3	THRUST PAD
-4	1	RBD29932-4	PULLER SCREW
7	1	Monroe#TP-750 OR EQUIV.	BLACK OXIDE STEEL TOGGLE PAD TYPE TP 3/4"-10 X 1-1/4" OD.
8	3	AN8-24A	BOLT
9	3	AN315-8R	NUT
10	6	NAS1149F0832P	WASHER



SECTION A-A

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193874 MLC
190424



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 8 THEN ASSEMBLE WITH ITEM 9, AND REMOVE EXCESS
- 9) TORQUE ITEM 9 TO 40-58 FT-LBS (480-690 IN-LBS)
- 10) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM 7 AND ITEM -3, AND REMOVE EXCESS
- 11) INSTALL ITEMS 7 HAND TIGHT
- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

RBD29932 MAIN ROTOR PULLER "D" MODEL (3 JAWS) AI

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A	NEW ISSUE	19-643	MBB
REV.	DESCRIPTION	ECN #	BY
DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	DP	RBD29932	SHEET 1 OF 7
APPROVED	VAP	TITLE	SCALE
		MAIN ROTOR PULLER "D" MODEL (3 JAWS) AI	NTS
DATE	4/2/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					